

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012604**Date Inspected:** 22-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:			

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port

Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

In Process Inspections:

This inspector witnessed SMAW being performed on the 7AE to 7BE side plate transverse splice, counterweight side. These welds were identified as OBW7B-001 and OBW7B-002. The welder was identified as 068917. ZPMC QC was identified as Mr. Li Yang. The welding procedure used for this operation was identified as WPS-B-P-2214-B-U2-FCW-1.

This inspector witnessed trial fitup of the counter weight assembly on OBG segment 6CW.

This inspector witnessed SMAW being performed on the 7AW to 7BW side plate transverse splice, cross beam side. These welds were identified as OBE7B-001 and OBE7-002. The welder was identified as 067609. ZPMC QC was identified as Mr. Shen Jian Bo. The welding procedure used for this operation was identified as WPS-B-P-2214-B-U2.

This inspector witnessed Magnetic Particle Testing, MT, being performed by ABF after base metal repairs on

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section 6AW counter weight side LD. MT operator was identified as Mr. Huang Zheng Chao. One indication was noted in the cover pass by Mr. Chao.

This inspector witnessed Ultrasonic Testing, UT, by ABF after base metal repairs on section 6AW counter weight side LD. UT operator was identified as S007. No recordable indication was noted at the time of testing.

This inspector witnessed weld repairs in accordance with CWR 1098. The weld procedure used for these repairs was identified as WPS-345-SMAW-1G-(1F)-Repair. The ZPMC QC was identified as Mr. Zhong Yong Gang.

This inspector witnessed weld repairs in accordance with CWR 1138. The weld procedure used for these repairs was identified as WPS-345-SMAW-4G-(4F)-Repair-1. The ZPMC QC was identified as Mr. Zhong Guo Hui. The welder was identified as 069683.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
